DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1x.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027495
Date Inspected: 23-Apr-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: On Site

CWI Name: Bernie Docena

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS OBG Components

Summary of Items Observed:

This Quality Assurance (QA) Inspector, Art Peterson arrived on site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor the welding operations performed by American Bridge Fluor (ABF) welding personnel. The following observations were:

Segment 12W between PP109 and PP109.5 W5 Line - Deck Access Hole LS West:

This QA Inspector observed ABF welder Kit Lounechany (Welder ID 4985) performing the complete-joint penetration (CJP) groove weld operation (2nd side) per the Shielded Metal Arc Welding (SMAW) process in the (3G) vertical position connecting the Deck Access Hole (DAH) insert plate Longitudinal Stiffener (LS) West to the Deck "A" plate LS 6 between panel point PP109 and PP109.5 along Grid line W5.

This QA Inspector observed QC Inspector Sal Marino verify prior to the start of the CJP groove weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterwords verified that the welding parameters (Amps and Travel Speed) were in accordance with WPS 1012-3 Revision 0 using E9018 (1/8") diameter electrode.

This QA Inspector observed ABF welder Kit Lounechany completed the welding of the (2nd side) of the CJP groove weld by the end of this QA Inspectors' shift.

Segment 12W between PP109 and PP109.5 W2 Line - Deck Access Hole LS West:

This QA Inspector observed ABF welder Steve Davis (Welder ID 7889) performing the complete-joint penetration (CJP) groove weld operation (2nd side) per the Shielded Metal Arc Welding (SMAW) process in the (3G) vertical position connecting the Deck Access Hole (DAH) insert plate Longitudinal Stiffener (LS) West to the Deck "A" plate LS between panel point PP109 and PP109.5 along Grid line W2.

This QA Inspector observed QC Inspector Sal Marino verify prior to the start of the CJP groove weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterwords verified that the welding parameters (Amps and Travel Speed) were in accordance with WPS 1012-3 Revision 0 using E9018 (1/8") diameter electrode.

This QA Inspector observed ABF welder Steve Davis completed the welding of the (2nd side) of the CJP groove weld by the end of this QA Inspectors' shift.

Segment 12E between PP109 and PP109.5 E2 Line - Deck Access Hole:

This QA Inspector observed ABF welder Eddie Brown (Welder ID 9331) performing the fill and cover pass weld operation on the (2nd side) of a complete-joint penetration groove weld per the Shielded Metal Arc Welding (SMAW) process in the (4G) overhead position on the Deck Access Hole (DAH) insert plate welded to the Deck "A" plate between panel point PP109 and PP109.5 along Grid Line E2.

This QA Inspector observed QC Inspector Sal Marino verify prior to the start of the fill and cover pass weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterwords verified that the welding parameters (Amps and Travel Speed) were in accordance with WPS 1010 Revision 1 using E7018 (1/8") diameter electrode.

This QA Inspector observed that ABF welder Eddie Brown was in-process welding the (2nd side) of the CJP groove weld operation at the end of this QA Inspectors' shift.

PP120 ~ PP124.7 Segment 13E Grid Line E2.0 ~ E2.8

This QA Inspector observed ABF personnel performing the erection of the Deck Plate Drop-in sections between PP120 ~ PP124.7 on Segment 13E along Grid Line E2.0 and E2.8. The Deck Plate Drop-in erection plan was to be in accordance with ABF-SUB-002652R00.

Afterwords, this QA Inspector observed ABF Welder Rick Clayborn performing the fillet weld operation per the Shielded Metal Arc Welding (SMAW) process in the (2F) horizontal position connecting the blank nuts to the deck plate for installation of the key plates to adjust the longitudinal weld splice planar offset between the Deck Plate section and Deck Plate Drop-in section along Grid E2.8.

This QA Inspector observed QC Inspector Bernie Docena verify prior to the start of the fillet weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterwords verified that the welding parameters (Amps and Travel Speed) were in accordance with WPS F1200A using E7018 (1/8") diameter electrode.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This QA Inspector observed that ABF welder Rick Clayborn was in-process fillet welding the blank nuts to the Deck Plate section and Deck Plate Drop-in section along Grid E2.8 at the end of this QA Inspectors' shift.

Summary of Conversations:

Only general conversations between this QAI and QC on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Peterson,Art	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer